

Work Order ID 73845

Friday, September 16, 2011 12:36:39 PM

Page 1

Item ID: D2661-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/16/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 10.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2661

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Fixturing Inspection last completed
11/11/19 by B.A. ☐ 1-Machine Step No 1 of Folio and visually inspect as
per attached Dimension Sheet ☐ 2-Machine Step No 2 of Folio and visually
inspect as per attached Dimension

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2661-2

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Setup Start



Revision ID:

Stop



Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

and 11/11/22

10 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10X 0 M-L 11/11/22

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3:00

3200 F

3:30

10X 0 M-L 11/11/22

M118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73845

Friday, September 16, 2011 12:36:39 PM



Page 3

Item ID:	D2661-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, RH Fwd Aft Out 206					
Start Date:	9/16/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	11/4/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				10	BR	11-11-22	
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>435</u> Memo	0.00 0.00				(100)	SP	11-11-23	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/11/23	

UMF
11-11-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 12:36:37 PM

Page 1

Work Order ID: 73845



Parent Item: D2661-2



Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/16/2011

Required Date: 11/4/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C000.11.01 Removed P/O for Powder Coat - in house process EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-003		Manufactured	No			100	Each	13.0000	1	10			
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Saddle Billet, 7075



FK- 11/11/18

Location	Loc Qty	Loc Code
MAT040	8	
72226	8	
MAT44	5	
72226	5	
B74650 x 10		

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 73845
Description: 206 Saddle, Inboard, Left side		Part Number: D2662-2
D2661		
Inspection Dwg: D2662 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	5 Date
A	0.100	0.140		0.125	0.125	0.125	0.125		0.125
B	0.100	0.140		0.132	0.132	0.132	0.132		0.132
C	1.125	1.145		1.1345	1.1342	1.1348	1.1347		1.1347
D	0.615	0.685		0.680	0.680	0.680	0.680		0.680
E	0.240	0.260		0.256	0.256	0.256	0.256		0.256
F	1.313	1.343		1.328	1.328	1.328	1.328		1.328
G	0.210	0.230		0.227	0.227	0.227	0.227		0.227
H	0.100	0.180		0.135	0.135	0.135	0.135		0.135
I	2.470	2.510		2.490	2.490	2.490	2.490		2.490
J	1.565	1.585		1.5745	1.5731	1.5734	1.5735		1.5728
K	0.235	0.240		0.237	0.237	0.237	0.237		0.237
L	0.100	0.120		0.109	0.109	0.109	0.109		0.109
M	0.990	1.010		0.999	0.999	0.999	0.999		0.999
N	0.510	0.515		0.512	0.512	0.512	0.512		0.512
O	5.990	6.010		6.000	6.000	6.000	6.000		6.000
P	1.245	1.255		1.250	1.250	1.250	1.250		1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500		2.500
R	0.313	0.318		0.314	0.314	0.314	0.314		0.314
S	0.315	0.322		0.316	0.316	0.316	0.316		0.316
T	2.495	2.505		2.500	2.500	2.500	2.500		2.500
U	1.357	1.367		1.362	1.362	1.362	1.362		1.362
V	0.787	0.807		0.797	0.797	0.797	0.797		0.797
W	0.540	0.560		0.550	0.550	0.550	0.550		0.550
X	1.674	1.684		1.679	1.679	1.679	1.679		1.679
Y	0.257	0.262		0.260	0.260	0.260	0.260		0.260
Z	0.912	0.932		0.922	0.922	0.922	0.922		0.922
AA	0.490	0.510		0.497	0.498	0.498	0.500		0.500
AB	0.178	0.198		0.188	0.188	0.188	0.188		0.188
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>MA</u>
Date: <u>11/11/19</u>

Audited by: <u>amf</u>
Date: <u>11/11/22</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order: 73845
Description: 206 Saddle, Inboard, Left side		Part Number: D26621
Inspection Dwg: D2662 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				#	10 Date
				16	17	18	19		
A	0.100	0.140		0.125	0.125	0.125	0.125		0.125
B	0.100	0.140		0.132	0.133	0.132	0.132		0.132
C	1.125	1.145		1.1347	1.134	1.1344	1.1345		1.1351
D	0.615	0.685		0.680	0.680	0.680	0.680		0.680
E	0.240	0.260		0.256	0.256	0.256	0.256		0.256
F	1.313	1.343		1.328	1.328	1.328	1.328		1.328
G	0.210	0.230		0.227	0.227	0.228	0.227		0.227
H	0.100	0.180		0.135	0.135	0.135	0.135		0.135
I	2.470	2.510		2.490	2.490	2.490	2.490		2.490
J	1.565	1.585		1.5737	1.5739	1.5744	1.5744		1.5751
K	0.235	0.240		0.237	0.237	0.237	0.237		0.237
L	0.100	0.120		0.109	0.109	0.109	0.109		0.109
M	0.990	1.010		0.999	0.999	0.999	0.999		0.999
N	0.510	0.515		0.512	0.512	0.512	0.512		0.512
O	5.990	6.010		6.000	6.000	6.000	6.000		6.000
P	1.245	1.255		1.250	1.250	1.250	1.250		1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500		2.500
R	0.313	0.318		0.314	0.314	0.314	0.314		0.314
S	0.315	0.322		0.316	0.316	0.316	0.316		0.316
T	2.495	2.505		2.500	2.500	2.500	2.500		2.500
U	1.357	1.367		1.362	1.362	1.362	1.362		1.362
V	0.787	0.807		0.797	0.797	0.797	0.797		0.797
W	0.540	0.560		0.550	0.550	0.550	0.550		0.550
X	1.674	1.684		1.679	1.679	1.679	1.679		1.679
Y	0.257	0.262		0.260	0.260	0.260	0.260		0.260
Z	0.912	0.932		0.922	0.922	0.922	0.922		0.922
AA	0.490	0.510		0.500	0.500	0.500	0.500		0.500
AB	0.178	0.198		0.188	0.188	0.188	0.188		0.188
AC									
AD									
AE									
AF									
Accept/Reject									

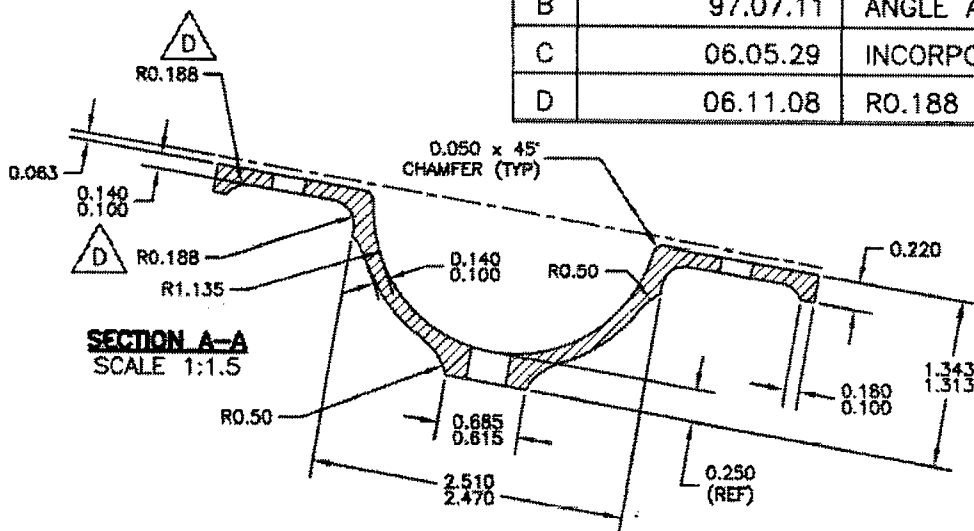
Measured by: MA
Date: 11/11/19

Audited by: CMJ
Date: 11/11/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



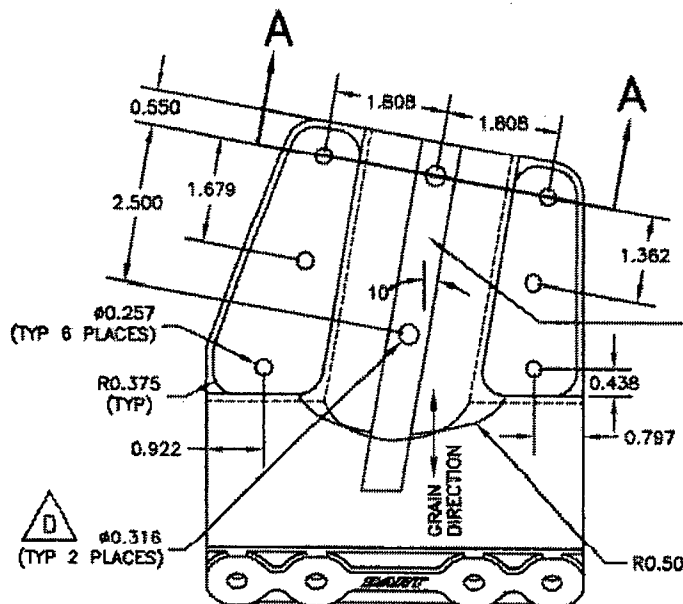
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				PORT HADLOCK, WA	
CHECKED	<i>PH</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
				D2661	SHEET 1 OF 1
DATE	06.11.08			TITLE	SCALE
				SADDLE OUTSIDE	1:3
A	97.03.25	NEW ISSUE			
B	97.07.11	ANGLE AND NOTES ADDED			
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095			
D	06.11.08	RO.188 WAS RO.30; Ø0.316 WAS Ø0.313			



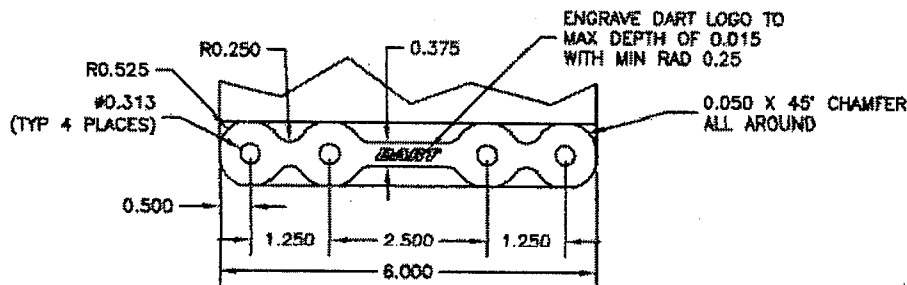
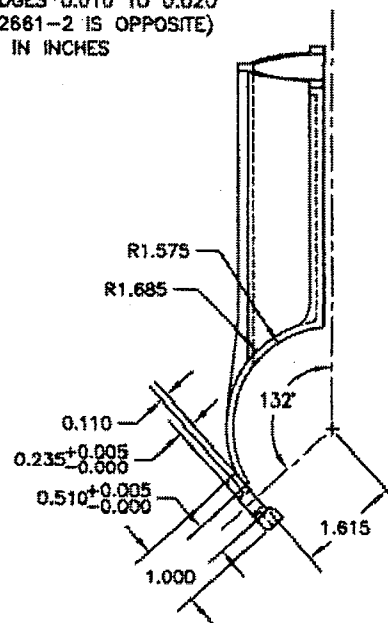
RELEASED
07.02.12 *[Signature]*

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH OF
0.010 WITH
MIN RADIUS
OF 0.010



D2661-1 SADDLE OUTSIDE

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